

Work Order ID 163415

Tuesday, June 27, 2017 11:39:16 AM

163415

Page 1

Item ID: D4770-047 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar Weldment
Start Date: 6/29/2017 Start Qty: 4.00 ***4*** **DAS 21 9-89** Cust Item ID:
Required Date: 7/10/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **JUL 03 2017** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4770	C								

100 0.00
100
Cold Saw Memo 0.20 **8 Q.L 17-07-10**
Hyd Mech 1- CUT D4770-7 BLANKS AT 26.0"

110 Weld per dwg & QSI004 4.5 0.00
110
autoweld 1 Memo 1.20 **8 Q.L 17-08-14**
Automated Welding 1
SEE NOTE 8 FOR SURFACE BUILDUP
1- USE GRINDER TO CHAMFER END AS PER DWG .
FOR AUTOMATED WELDING USE 8259 HARDCOAT
BATCH: **MB2716**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																									

163415

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/29/2017 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 7/10/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.08

Quality Control

⑧ 1708.15 DAS
9
989

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.08

Quality Control

② 12x15

140

Identify as per dwg & Stock Location: Waco

0.00

140

Packaging

Memo

0.08

Packaging

LOCATION: WA001

Q.L 17-08-15

DQA: _____ Date: _____



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.40							
Quality Control									

UM 8/15/17

DAS
21
9-89DAS
21
9-89

AUG 21 2017

DQA: _____ Date: _____



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Description Work Order Deviation				Disposition				Completed By	
140 13 12 140 13 12								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
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Picklist Print

Tuesday, June 27, 2017 11:39:14 AM

Page 1

Work Order ID: 163415

163415

Parent Item: D4770-047

D4770-047

Parent Item Name: Bar Weldment

Start Date: 6/29/2017

Required Date: 7/10/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 17.04.17 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	126.5780	2.16	9.094737			
M304B0 250x0 500									**	Q.L 17-08-14			
304 BAR .250 x .500													

Location

WA002

Loc Qty

126.578

Loc Code

m137512

22.57

m137065

13.2

m137172

6.808

m137824

84

~~126.5780~~
~~22.57~~
~~13.2~~
~~6.808~~
~~84~~

~~126.5780~~
~~22.57~~
~~13.2~~
~~6.808~~
~~84~~

7,52
13,2
3,89
5,29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

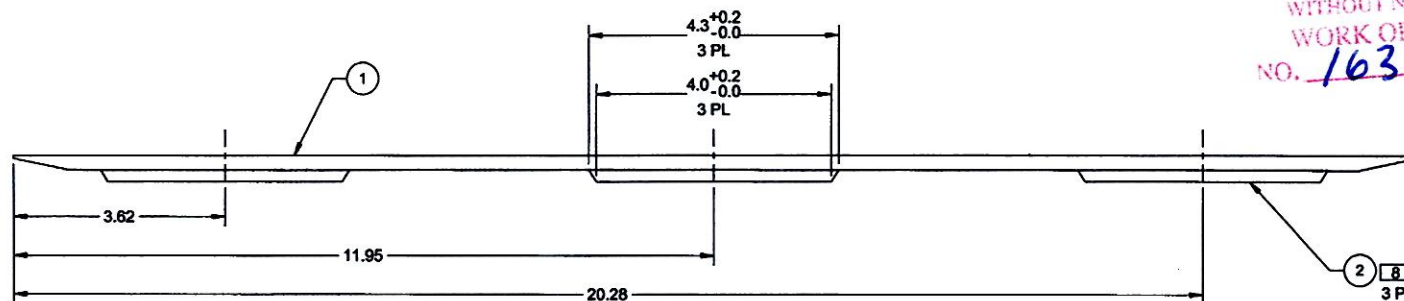
QA Closed: _____ Date: _____

Work Order update only ☐

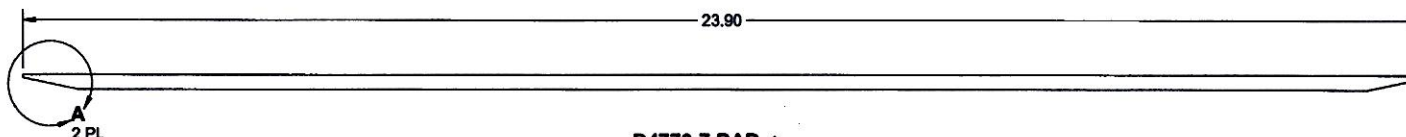
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ITEM	QTY -047	P/N	DESCRIPTION
	X	D4770-047	BAR WELDMENT
1	1	D4770-7	BAR
2	A/R	8259/2059B	HARD SURFACING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163415 MWS
17-0703



D4770-047 BAR WELDMENT ⚠



D4770-7 BAR ⚠

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF DART SPEC. M304B0.250X0.500

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 1.17 lbs

8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

RELEASED

2017 APR 10 47

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	SAD	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4770	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DE	BAR	NTS
DATE	17.02.14	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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PARTS IN STOCK ARE MADE TO D4770 Rev.B				Acceptable to make parts to D4770 Rev.B. Changes in Rev.C were to facilitate production.																																																																			
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